

Work Order ID 56565

*Monday, March 01, 2010 2:43:39 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 3/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *JMF*

Date: 10-3-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100



DC

DOCUMENT CONTROL

Document Control

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A HJ

110



BENDING MACHINE - SKIDTUBES

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

>DP 10-3-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan:

Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

120

Operation
DescriptionSet Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Memo

- 1- Deburr ends
- 2- C'sink holes as per dwg without cutting fluid
- 3- Prepare tube for welding, remove alodine as required.
- 4- Scribe batch number insied aft end of tube.

10-3-3

130



QC5- Inspect part completeness to step on W/O

0.00

QC
Quality Control

Memo

0.00

④

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

140



Skidtubes

Skidtubes

Operation
Description

Set Up/
Run Hours
0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

m113207

BE 10/03/03

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

m113207

BE 10/03/03

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 10/03/04

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/
Run Hours

0.00

S 10/03/04

Draw
Number

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Run

Start

Stop

Run

Start

Stop

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/03/04

Memo

0.00

(X)

(X)

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

PRESSURE-WASH

= 7 M 10/03/04

(X) 6

W/O:		WORK ORDER CHANGES					
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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

180



Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

1113170

Set Up/
Run Hours

0.00

=>41

Draw
Number

10/63/09

Draw
Rev.

0

Plan
Code

X1

Accept
Qty

0

Reject
Qty

0

Reject
Number

0

Insp.
Stamp

/

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 10-310

D. S.

Memo

0.00

START TIME: 11:30 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 12:00 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

200

Operation
DescriptionSet Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

HandFinish

Hand Finishing

Memo 0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M112345Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M112345Sikaflex expire date: 10/085-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M113462

PL 10-3-10 1

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 3/15/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Sulorlu

0.00

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041
Location:
PPP Rev: *PPD 56404*

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*Recd/1/11**10/03/16 JF**MF
10-3-11*

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041



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Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1



Manufactured	No	110	Each	4.0000	1.0000
--------------	----	-----	------	--------	--------

205 Skidtube bent detail

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Location		
Main Warehouse		
LG B56121	4	①
54541	2	
56123	2	

DP 10-3-3

D2576-3



Manufactured	No	140	Each	132.0000	1.0000
--------------	----	-----	------	----------	--------

Step (machining detail)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Location		
Main Warehouse		
ST	132	
46661	85	
52215	47	

1 8E 10/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2579



Manufactured No

140

Each

216.0000

20.0000



Crossbolt Spacer

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
LG	94	
51525	4	
53780	3	
54543	18	
56145	69	
Main Warehouse		
ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

20

86 10/03/03

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Shop Packet Print

Page 2

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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2855



Cap

Manufactured	No	200	Each	149.0000	1.0000
--------------	----	-----	------	----------	--------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

ST026	149
50513	1
50770	1
51539	37
53791✓	110

1 BK 10-3-10.

AN3-5A



Bolt

Purchased	No	200	Each	1,431.000	2.0000
-----------	----	-----	------	-----------	--------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

ST	1431
100188	188
105057✓	1243

2 BK 10-3-10.

W/O:		WORK ORDER CHANGES					
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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L



Purchased

No

200

Each

3,197.000 2,0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST	3197	
101291	16	
105793	49	
110985 ✓	3132	

ALS7-1032-130



Purchased

No

200

Each

986.0000 50.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST 110511	986	
108606	52	
111529	130	
111779	34	
112772	11	
113238	759	

ALS4-1032-130.

2. bl 10-3-10

50 bl 10-3-10.

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



Purchased

No

200

Each

1,033.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST 114103	1033
112314	13
112720	12
112724	3
112829	1
112991	2
113121	64
113226	344
113749	394
	200

13 BL 10-3-10

AN960C10L



Purchased

No

200

Each

388.0000 50.0000



washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG	118737
----	--------

Main Warehouse

ST	100
103585	100
	288
112116	128
112612	160

50. BL 10-3-10 .

W/O:		WORK ORDER CHANGES					
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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13



Manufactured

No

200

Each

79.0000

1.0000



Gasket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

FP	77	
53461 ✓	77	

1 Bl 103-10.

Main Warehouse

ST	2	
45717	1	
50265	1	

1

D3566-5



Manufactured

No

200

Each

31.0000



Gasket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

FP19	27	
55026 ✓	15	
55335	12	

1 Bl 103-10

Main Warehouse

ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

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Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1



Gasket

Manufactured	No	200	Each	33.0000	2.0000
--------------	----	-----	------	---------	--------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	28	
52512	3	
54480	1	
55011	1	
55320 ✓	23	

2 BK 10-3-10.

Main Warehouse	ST	5
	46349	1
	51218	1
	51259	3

2 BK 10-3-10.

D3564-11



Wearshoe

Manufactured	No	200	Each	16.0000	1.0000
--------------	----	-----	------	---------	--------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	14	
52125 ✓	2	
55332 ✓	12	
Main Warehouse		
ST	2	
45823	1	
50112	1	

1 BK 10-3-10

Monday, March 01, 2010 2:43:39 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:43:39 PM

Page 8

Work Order ID: 56565



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13



Manufactured

No

200

Each

19.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17 50285

7

51611

7

Main Warehouse

ST

12

45409

2

46495

10

D3564-9



Manufactured

No

200

Each

25.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

23

55025

11

55334

12

Main Warehouse

ST

2

44659

1

45825

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Mondgy, March 01, 2010 2:43:39 PM

Page 9

Work Order ID: 56565



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5



Manufactured

No

200

Each

41.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	37	
51925	1	
54772✓	11	
55024	12	
55333	13	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 Blk 10-3-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:43:39 PM

Page 10

Work Order ID: 56565



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3



O-Ring, 205 Skidtube

Manufactured	No	200	Each	628.0000	16.0000
--------------	----	-----	------	----------	---------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	527	
51613	27	
55546 ✓	500	
Main Warehouse		
ST	101	
52562	101	

MR 10-3-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 2:43:39 PM

Page 11

Work Order ID: 56565



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 3/2/2010

Required Date: 3/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-1



Manufactured

No

200

Each

689.0000

16.0000

Plug, 205 Skidtube



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	561	
54008	1	
54643	15	
55002 ✓	545	
Main Warehouse		
ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	

16. Blk 103-10,

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. D
		D2580	SHEET 1 OF 3
DATE		TITLE	SCALE
07.02.27		205 SKIDTUBE ASSEMBLY	NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

#56565

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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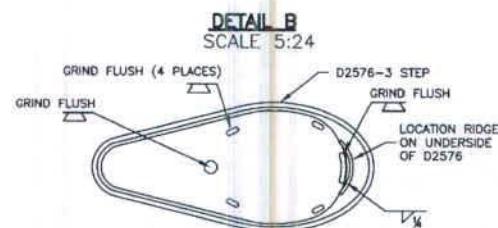
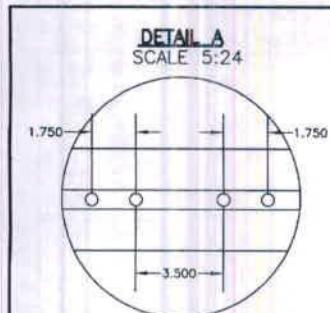
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

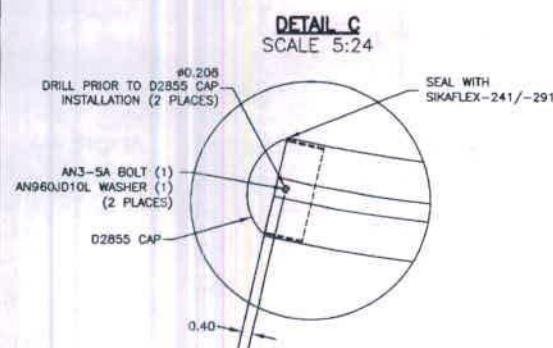
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

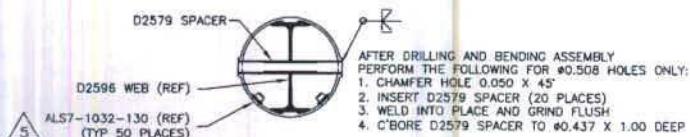
NOTE: Date & initial all entries



RELEASED
07-06-28

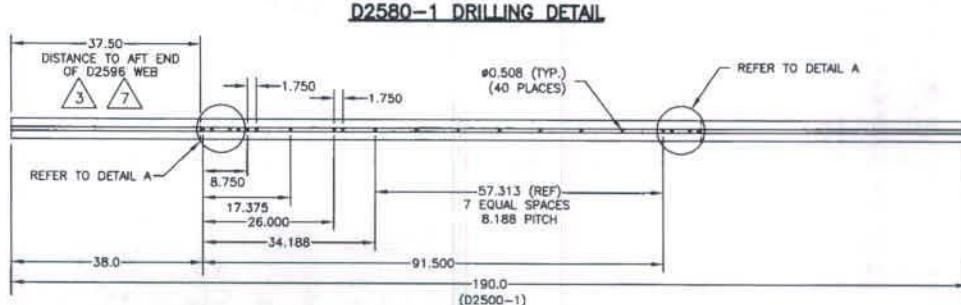


SECTION D-D
SCALE 5:24

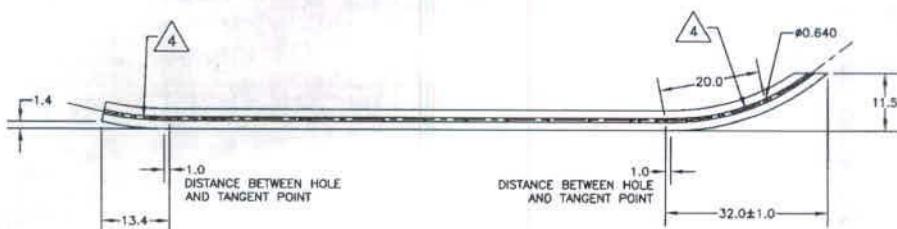


D2580-041 NOTES

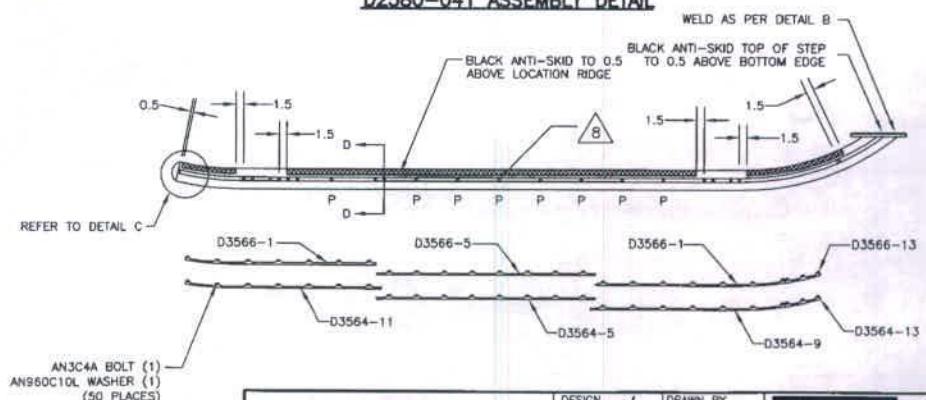
- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARROWSBURY, ONTARIO, CANADA
CHECKED	APPROVED	#	DRAWING NO. D2580
DATE			SHEET 2 OF 3 TITLE 205 SKIDTUBE ASSEMBLY
07.02.27			SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: SG134
Part number: D205 634.041
Description: 205 skid tube
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 10-02-23

Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

